

Work Order ID 60104

June 24, 2010 11:18:51 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 6/24/10 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/6/24 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3825

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825
A/R S.S. Rod Batch: 111 079

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

SAD 10-06-28

⑥ CL 10-06-29

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60104

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Item ID: D3825-041

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Customer:

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Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(6)	10.07.01		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(46)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <i>Basket</i> Memo	0.00 0.00				(6)	10.07.01		

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60104

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Item ID: D3825-041

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Start Date: 6/24/10 Start Qty: 6.00

Cust Item ID:

Required Date: 6/30/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *[Signature]**MF*
10-17-01

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 11:18:50 AM

Page 1

Work Order ID: 60104

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 6/24/10

Start Qty: 6.00

Required Date: 6/30/10

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	11.0000	1	6			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			11						
				58406			1						
				58974			10						
D3759-1 Bushing		Manufactured	No			100	Each	81.0000		6			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			81						
				54072			9						
				59419			30						
				59644			42						
M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	630.8996	2.125	13.42105			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT			1.4628						
				112398			0						
				114482			1.4628						
				WA			629.436835						
				114520			629.436835						

PL 10-06-29

6

PL 10-06-29

6

SAD 10-06-28

13.42105

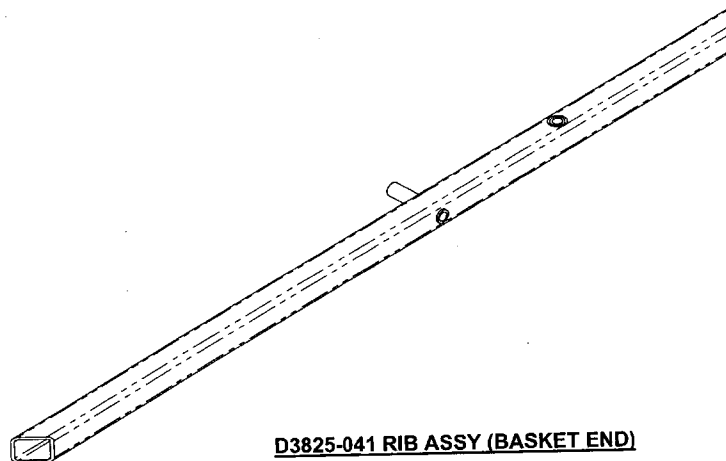
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3825-041 RIB ASSY (BASKET END)

ITEM	QTY	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

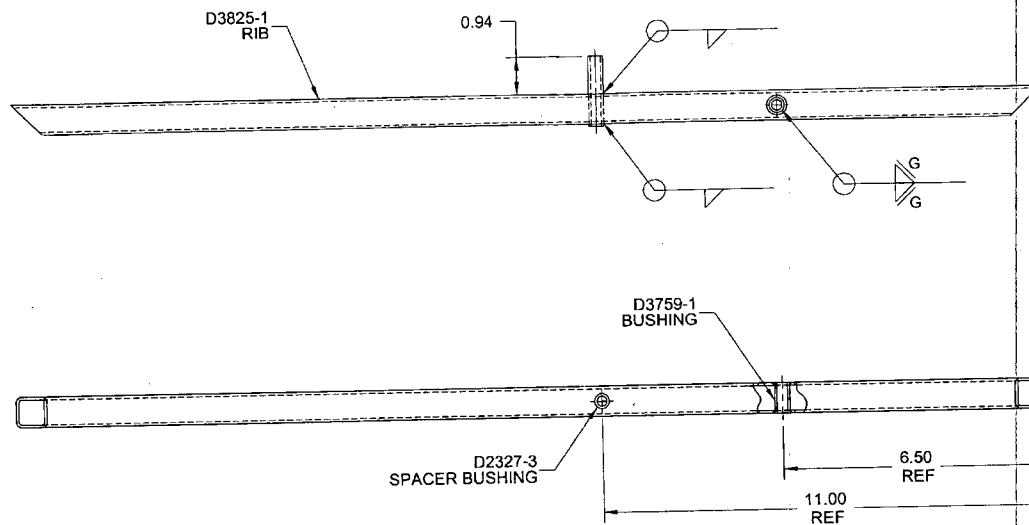
CL10/6/24
W10.60104

RELEASED
08/11/24

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3825	REV. A
TITLE RIB ASSY (BASKET END)	SCALE NTS
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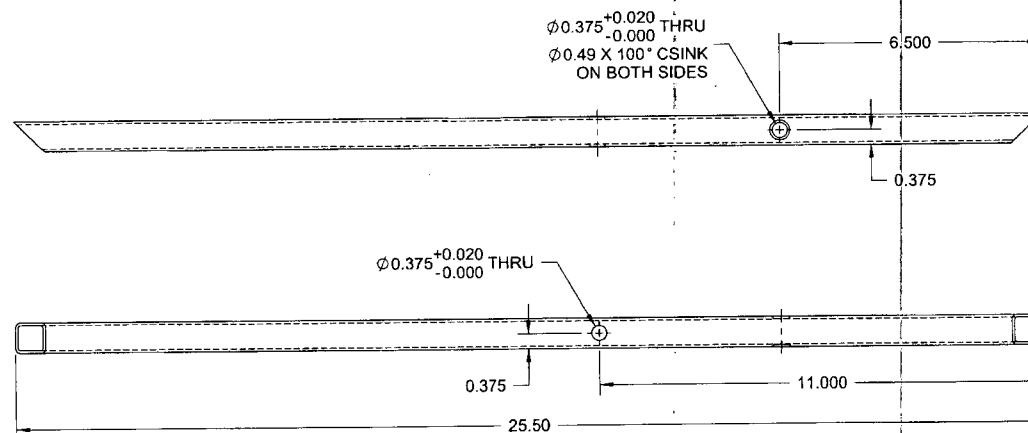
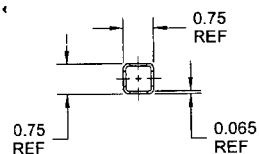


D3825-041 RIB ASSY (BASKET END)

W/O 60104

RELEASED
06/11/18 JWP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JWS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
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DE APPR.		RIB ASSY (BASKET END)	NTS
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D3825-1 RIB

W/O: 60104

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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